Page 1

Work Order ID 71676 Thursday, July 07, 2011 12:12:08 PM Accept Setup Start Item ID: D3255-2 **Revision ID:** Stop Item Name: Panel Start Qty: 8.00 **Start Date:** 7/7/2011 **Cust Item ID:** Required Date: 7/21/2011 Reg'd Oty: 8.00 **Customer:** Reference: Start Run Date: 1/07/07 Tooling: Approvals? Process Plan: Date: Stop Date: SPC (Y/N): Date: Sequence_ID/ Set Up/ Tool # Plan Accept Reject Reject Insp. Operation Tool ID Stamp Work Center ID Description Code Qty Qty Number **Run Hours** Draw Nor **Revision Nbr** Rev B D3255 0.00 100 FLOW WATER JET 1B11-8-10 0.00 Waterjet Memo □Prog Rev: R □2-1-Cut as per Dwg D3255 □Dwg Rev: FLOW CNC Waterjet Deburr if necessary 304.03> QC2- Inspect parts off machine FAI/FAIB 0.00 110 1311-8-10 0.00 Memo **Quality Control**

120

QC

Quality Control

Memo

QC8- Inspect parts - second check



W/O:		WORK ORDER CHANGES											
DATE	STEP	STEP PROCEDURE CHANGE By Date Oty Chief From (Approval QC Inspector										
					,								
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Y	es N	o DQ	A:	Date: _				
	R	esolution:	Disposition);	_ QA: N/	C Clos	sed:		Date: _				
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (N	ICR)							
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval			
DAIL	316	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Secti	on C	Chief Eng	QC Inspector			
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NOTĘ: Date & initial all entries

Work Order ID 71676

Thursday, July 07, 2011 12:12:08 PM



Page 2

Item ID:

D3255-2

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Panel

Required Date: 7/21/2011

Start Qty: 8.00 7/7/2011

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date: Date: Run

Start

Stop



Date: _____

SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation **Description**

Req'd Qty: 8.00

NC BRAKE

Memo

Form as per Dwg D3255

Set Up/ **Run Hours**

0.00

0.00

S& 11/08/23

140

Quality Control

QC5- Inspect part completeness to step on W/O

150

Packaging Packaging

Identify as per dwg & Stock Location: 18 WA



Memo

Memo

0.00

76-80-11 OB

	1												
W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			•										
Part No	:	PAR #:	Fault Ca	tegory:	NCR	: Yes I	No DQ	A:	_ Date: _				
	Re	esolution:	Disposit	ion:	QA:	N/C Clo	sed:		Date:				
NCR:		\	WORK OR	DER NON-CONFORM	IANCE	(NCR)						
DATE	STEP	Description of NC				verifica			Approval	Approval			
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Secti	on C	Chief Eng	QC Inspector			
				·					·				
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NOTE: Date & initial all entries

W	ork	Orde	er ID	710	676

Thursday, July 07, 2011 12:12:08 PM



Page 3

Item ID:

D3255-2

Accept



Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Panel

7/7/2011

Start Qty: 8.00

Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:	Process	Plar
Approvais.	110003	ı ıaı

Required Date: 7/21/2011

Date: Date: Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop

Sequence ID/

Operation **Work Center ID** Description

QC:_

0.00

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Reject Qty Qty

Reject Number

160

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

Insp. Stamp

M-08-24

W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	Ву	Date	Qty	Approvai Chief Eng / Prod Mgr	Approval QC Inspector		
		·					<u></u>		
Part No	·	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A :	_ Date: _	
Resolution:		Disposition);	QA: N/C CI	osed:		Date: _		
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE		Description of NC	Corrective Action S		Section B		cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspecto
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NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:12:05 PM

Work Order ID: 71676

D3255-2

Parent Item Name: Panel



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

Parent Item:

IPP Rev:A New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	43.3600	1.484	12.49684			
										(B	1-8-11	<u>u</u>	

304/316 .032 Sheet

Location	Loc Qty	Loc Code		
020	5.8			(8)
109057	5.8			
MAT020	37.56			
117379	37.56		118400	
118400				

W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
			· ·						, gi				
•••			764 166,		*								
				. :									
Part No	:	PAR #:	Fault Category:	NCI	R: Yes	No DQ	A:	Date:					
	Re	esolution:	Disposition:	QA:	N/C C	losed:		Date: _					
NOD		V	VORK ORDER NON-CO	ONEORMANCE	(NCI	5/							

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	T	Description of NC		Corrective Action Section B		Verification	Annroval	Annexal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Signature Chief Eng Da		Section C	Approval Chief Eng	Approval QC Inspector			
		·									
· s.											

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	7/676
Description: Access Panel Assembly	Part Number:	D3255-2
Inspection Dwg: D3255 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

х	First Article	Prototype
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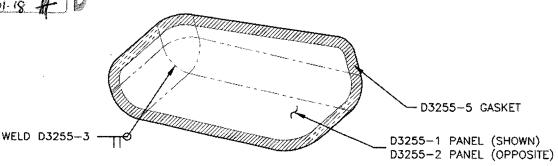
Drawing	T-1	Actual			Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø0.098	+0.004/-0.001	101	7		V 1862	
15.171	+/-0.010	15,171	8		T BUI	
10.032	+/-0.010	10.030	б		Т	
6.902	+/-0.010	6,897	7		7	
18.456	+/-0.010	18,496	8		7	
11.432	+/-0.010	11.437	7		٦	
2.261	+/-0.010	2.254	8		ν	
2.363	+/-0.010	2.357	7		ν	
2.363	+/-0.010	2,354	7		٧	
1.183	+/-0.010	1.185	ک		٧	
0.250	+/-0.010	744	>=		V	
0.250	+/-0.010	750	0		V	
2.261	+/-0.010	2254	×		V	

Measured by: B Audited by: C Prototype Ap	pproval: N/A
Date: 11 - 8-16 Date: WOSLY	Date: N/A

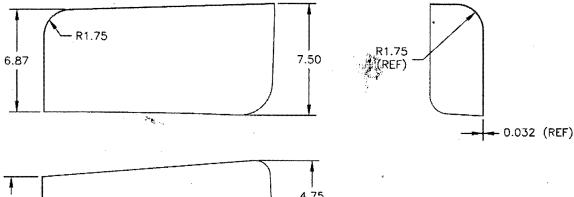
Rev	Date	Change	Revised by	Approved
Α	08.05.06	New Issue	KJ/DD 🛠	1
			• • • • • • • • • • • • • • • • • • • •	



DESIGN DRAWN BY			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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	41	di-	D3255 SHEET 1 OF	
DATE	•••••••••••••••••••••••••••••••••••••		TITLE SCAL	
04.12.06			ACCESS PANEL ASSEMBLY 1:	
Α		04.01.27	NEW ISSUE	
В		04.12.06	D3255-3 REDESIGN: ADDED Ø0.098	



D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



4.75 3.62 - R1.75 15.49 0.032 (REF) -

> D3255-1 BEND DETAIL D3255-2 OPPOSITE

SHOP COPY **RETURN TO ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO_7/676_

CZ(1107/0>

D3255-041/-042 NOTES:

WELD PER DART QSI 004

- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

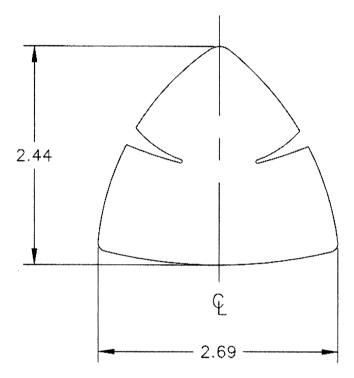
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CHECKED	APPROVED	DRAWING NO.	REV. B
"	1	D3255	SHEET 2 OF 4
DATE		TITLE	SCALE
04.12.06		TITLE	1:1





D3255-3 CAP FORM TO FIT D3155-1/-2

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 71676

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

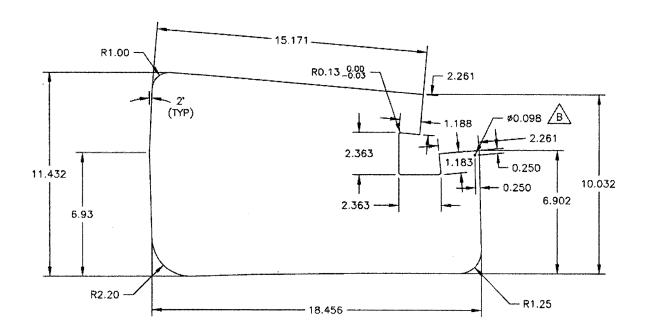
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CHECKED (P	APPROVED	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-1/-2 FLAT PATTERN

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 71676

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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